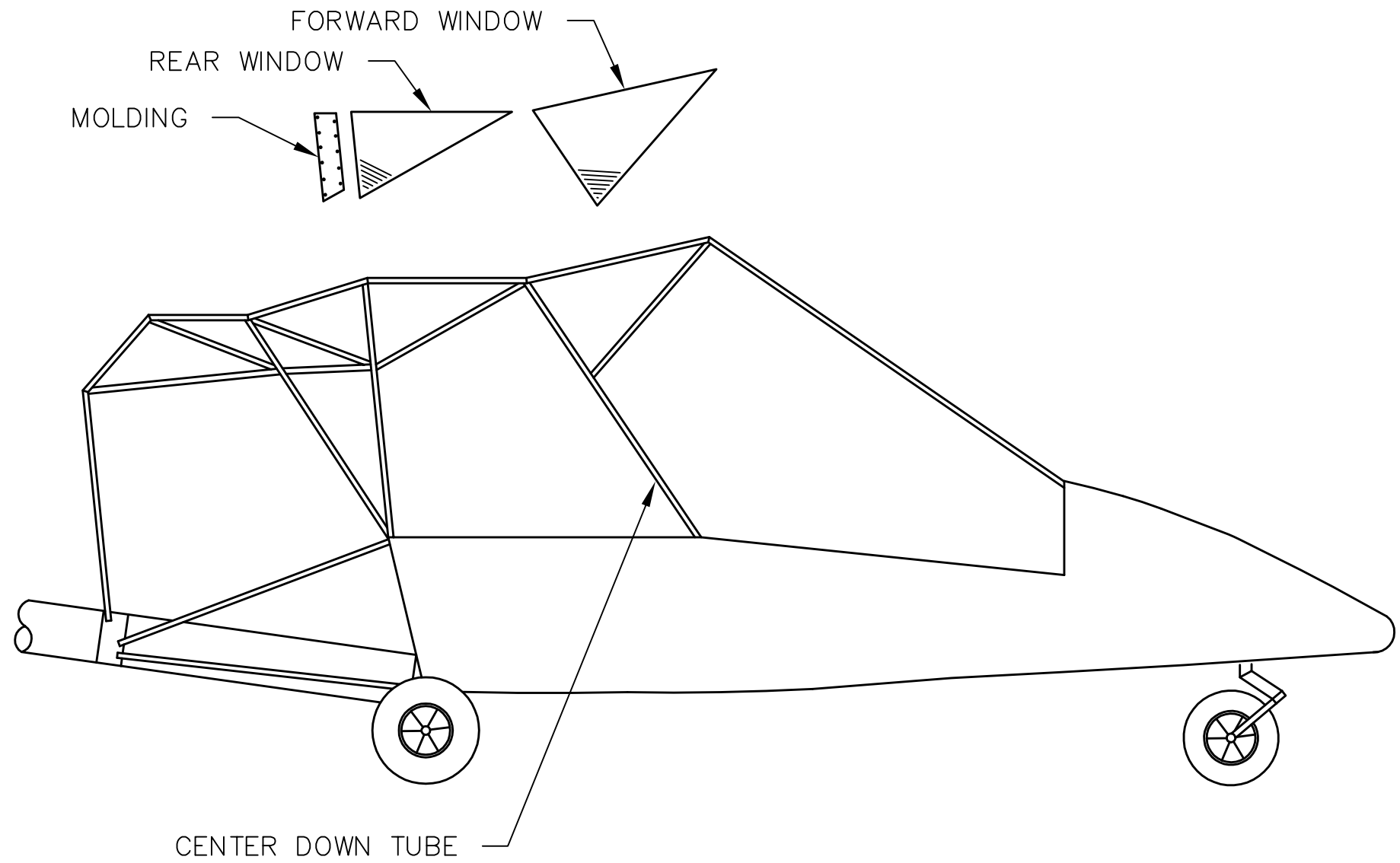


REVISIONS				
E.C. NO.	REV.	DESCRIPTION	BY	DATE
1020	B	NOTES ADDED	K.B.	10/96
1107	C	DRAWING WAS TWO PLACE ONLY	K.B.	6/97



- NOTES:
- CUT WINDOWS OUT OF LEXAN USING THE PROVIDED PATTERNS 1" - 2" OVERSIZED.
 - DRILL ALL MOUNTING HOLES ON 2.000 INCH CENTERS USING #30 DRILL ($\phi.1285$).
 - CLAMP FORWARD WINDOW ONTO FUSELAGE FRAME. DRILL MOUNTING HOLES ALONG ALL TUBES EXCEPT THE CENTER DOWN TUBE. DO NOT DRILL OR TRIM EXCESS ALONG CENTER DOWN TUBE UNTIL THE REAR DOOR IS INSTALLED.
 - CLAMP REAR WINDOW ONTO FUSELAGE FRAME. DRILL MOUNTING HOLES THRU ALL TUBES.
 - REMOVE REAR WINDOW. POSITION MOLDING ONTO REAR WINDOW SO THAT ITS EDGES ARE FLUSH WITH THE WINDOWS EDGES. DRILL MOUNTING HOLES USING EXISTING HOLES IN WINDOW AS A GUIDE.
 - DRILL MOUNTING HOLES THRU FORWARD EDGE OF MOLDING AND WINDOW.
 - CLECO REAR WINDOW AND MOLDING BACK ONTO FUSELAGE.
 - DO NOT RIVET UNTIL ALL WINDOWS HAVE BEEN FITTED. DO NOT RIVET ALONG TOP FUSELAGE TUBES UNTIL RUBBER GAP SEAL IS READY TO BE INSTALLED.
 - USE AD42ABSLF RIVETS ($\phi.125$ X .265 LONG) FOR WINDOW / FUSELAGE TUBE JOINTS.
 - USE AD42ABS RIVETS ($\phi.125$ X .265 LONG) AND #4 RIVET WASHERS ON FORWARD EDGE OF MOLDING AND WINDOW JOINT.
 - USE AD42ABS RIVETS ($\phi.125$ X .265 LONG) FOR MOLDING / WINDOW / FUSELAGE JOINT.

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TITAN AIRCRAFT SUPPLY
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 AUSTINBURG, OHIO 44010

DETAIL NAME		UPPER RIGHT WINDOW INSTALLATION	
SCALE	N/A	PART NO.	
ASSEMBLY NAME		SINGLE AND TWO PLACE TORNADO	
PART NO.		DRAWING NO.	
DRAWING NO.		B 92-INS-0314-C	

DRAWN	J. PRESTON	DATE	11/23/92
CHECKED	B. PASSAFIUME	DATE	6/11/97
APPROVED	J. SUTCH	DATE	6/20/97